Work Order ID 91540 - 2

91540

Page 1

October-12-12 11:26:32 AM Accept *N900040100* Setup Start D3849-043 Item ID: Revision ID: Stop AFT WEARPLATE ASSY, STD GEAR Item Name: Start Qty: 4.00 10/12/12 Cust Item ID: Start Date: Req'd Qty: 4.00 Required Date: 10/26/12 Customer: Reference: -42 Run Start Date: 12-10-12 Tooling: Date: Process Plan: MLJ Approvals: Stop Date: Date: SPC (Y/N): QC: Accept Reject Reject Set Up/ Tool ID Tool # Plan Insp. Operation Sequence ID/ Number Stamp Code Qty Qty Description **Run Hours** Work Center ID Revision Nbr Draw Nbr D3849 D 0.00 110 *110* 0.00 Large Fab Memo 1- On D3901-1 bar, fiil cut outs with hardcoat welding rod as per dwg D3849 Large Fab 2059 B Hardcoat Welding Rod BATCH#: > 2- Weld D3901-1 bar to wearplate as per dwg D3849 304 S.S. Welding Rod BATCH #: m//8/6/ 3- Transfer drill holes as per dwg 4- Cut excess bar material if necessary 0.00 120

QC9-Inspect visual per QSI004- Fusion Welds

120 QC

Memo

0.00

Quality Control

13:05-14

										DQA:	Date	
NCR: Y	'es / No				WORK ORDER NON-	COI	NFORM	MANCE / UPDATE		QA Closed:	Date	
					DISPOSITION			AGAINS	TDE	PARTMENT		,
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Part N					Rework Scrap Use-as-is		Therm	Skid-tube Crosstub Machining Small Fa Informing Finishir	b g		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update]		Large Fab Composit	e		Supplier	
Root				Descri	ption of work order update	П	Initial	Action		Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
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Equip/Tooling												
Operator												
Material												
Setup												
Other							1					
Process	=											
Supplier												
Training												
Unapproved												
					F	AUL	LT CATE	GORY				
Landir	ng Gear				General				_		-	
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to (D/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspection	on Incomplete		Part Incorre	ct	Weld
	Crushed,	/Crimped			Burrs		Instructi	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Tre	at			Countersink	2	Mislabe	led		Positioned V	Vrong	_
480	Inspectio	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
90	Ripples in	n Bend			Drill Holes		Offset				_	

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Work Order ID 91540

91540

Page 2

Item ID:

October-12-12 11:26:32 AM

D3849-043

Accept

N900040100

Setup Start

Revision ID:

Item Name:

Required Date: 10/26/12

AFT WEARPLATE ASSY, STD GEAR

Start Date:

10/12/12

QC:

Start Qty: 4.00 Req'd Qty: 4.00 *4*

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Sequence ID/

Process Plan:

Date: Date:

Tooling:

0.00

0.00

SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Tool#

Plan

Code

Run

Accept

Qty

Reject

Number

Reject

Qty

Work Center ID 130 *130* OC

Quality Control

140

150

140 Small Fab

Small Fab

1- Apply a layer of rockguard as per dwg

BATCH: 125226

QC5- Inspect part completeness to step on W/O

150

QC

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Memo

0.00

0.00

Start

13-05-14

Insp.

Stamp

NCR: Y	es i	/ No				WORK ORDER NON-	COL	VFORM	ANCE / UPI	DATE			
		20							50		QA Closed:	Date	2
Work Orde	er: _					DISPOSITION Rework	1	5	kid-tube	AGAINST DI	EPARTMENT,	/PROCESS Water Jet	Engineering
Part N						Scrap Use-as-is		M Thermo	achining	Small Fab Finishing Composite	-	d. Eng. Coor. re/Packaging Supplier	Quality Other
NCR N	10			-		Work Order Update		L	arge Fab	Composite	_	3dppliei _	
Root Cause		Date.	Step	Qty		ption of work order update or Non-conformance		nitial lief Eng	Act Descr	ion iption	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		Date. Step Qty											
Опоррготсо				l		F	AUL	T CATEG	ORY				
Landir	B C C	Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat			/s	General Bend BOM/Route Broken/Damaged Burrs Contamination		Instructio Mainten	n Incomplete ons Incomplete/U nance	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Ir R	spection	Strip in			Countersink Cut Too Short Drill Holes Drawing		Mislabele Misread Offset Out of Ca		E	Positioned V Power Loss/		Other

Outside Dimensions

Date:

DQA:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

Set Up/

0.00

0.00

0.00

Run Hours

Operation

Description

Memo

Memo

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location: FP-007 0.00

Sequence ID/

160 Packaging

170

Quality Control

Packaging

160

170

QC

Work Center ID

N900040100 Setup Start Stop Cust Item ID: Customer: Start Run Date: Stop Date: Reject Reject Tool ID Tool # Plan Accept Insp. Qty Qty Number Stamp Code

> mr 13-5-21

Page 3

NCR: Y	es / No			WORK ORDER NON-	-CONFORM	MANCE / UPI	DATE			
						5		QA Closed:	Date:	
Work Orde	r:			DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N				Rework Scrap Use-as-is	1	Skid-tube Machining noforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	0			Work Order Update		Large Fab	Composite]	Supplier	
Root				Description of work order update	Initial	Act	ion	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief Eng	Descr	iption	Date	Verification	QC Inspector
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Operator										
Material	_								1	
Setup			×							
Other		-								15
Process	_									(h)
Supplier	_	1			1					
Training	_									
Unapproved					FAULT CATE	GORY		<u> </u>		
Landin	ng Gear	_		General	TAOLI CATE	CONT				
Γ	Bending			Bend	Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to O		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
F	Cracks	or correct	inche to o	Broken/Damaged	A.O. Str. A.O. S.	ion Incomplete		Part Incorre		Weld
	Crushed/	Crimped		Burrs		tions Incomplete/L	Inclear	Part Lost/M	_	Wrong Stock Pulled
-	Cuffs	C. III. PCO		Contamination	Mainte			Part Moved		Transmission are entirely and
-	Heat Trea	at		Countersink	Mislabe		-	Positioned \		
	Inspectio		Tube	Cut Too Short	Misread			Power Loss,	11.010.000	Other
F	Ripples in			Drill Holes	Offset					
	Torque W		xtrusion	New pc		Calibration				

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 1

Work Order ID:

91540

Parent Item:

D3849-043

Parent Item Name:

AFT WEARPLATE ASSY, STD GEAR

Start Date: 10/12/12

Required Date: 10/26/12

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP RevA: New issue DD verified by:EC DWG REV.D DD VERF:JLM

IPP Rev:B 12.09.11 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3849-3 Plate	B 821	Manufactured	No			110	Each	13.0000	(4)	me	13	-05	-13
9057	6 B90	356 7	(7)	Location W/A		Loc Oty	<u>Lo</u>	c Code		P	73.	10.)
	B9309	50 →x8	2	826° 905°		11			X	2_		6	14

D3901-3 Bar

Manufactured

Loc Oty

8.0000

Loc Code

Location WA

90397

											DQA:	Date	
NCR:	Yes	/ No				WORK ORDER NON	-co	NFORM	MANCE / UPI	DATE			
											QA Closed:	Date	:
W 1 0 1						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde	er.					Rework			Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	Vo.					Scrap	\neg		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
111831.411	interior,					Use-as-is			noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR I	Vo.					Work Order Update			Large Fab	Composite		Supplier	
Root			Γ		Descri	I ption of work order update	Т	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	C	hief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other					, 2								
Process					4								
Supplier													
Training													
Unapproved											7 7		
							FAU	LT CATE	GORY				
Landi	ng (Gear			_	General	_	-			_		
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	O/S	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/I	Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved		
		Heat Trea	it			Countersink		Mislabe	eled		Positioned \	Wrong	_
		Inspection	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	'Surge	Other
		Ripples in	Bend			Drill Holes		Offset					

Out of Sequence

Outside Dimensions

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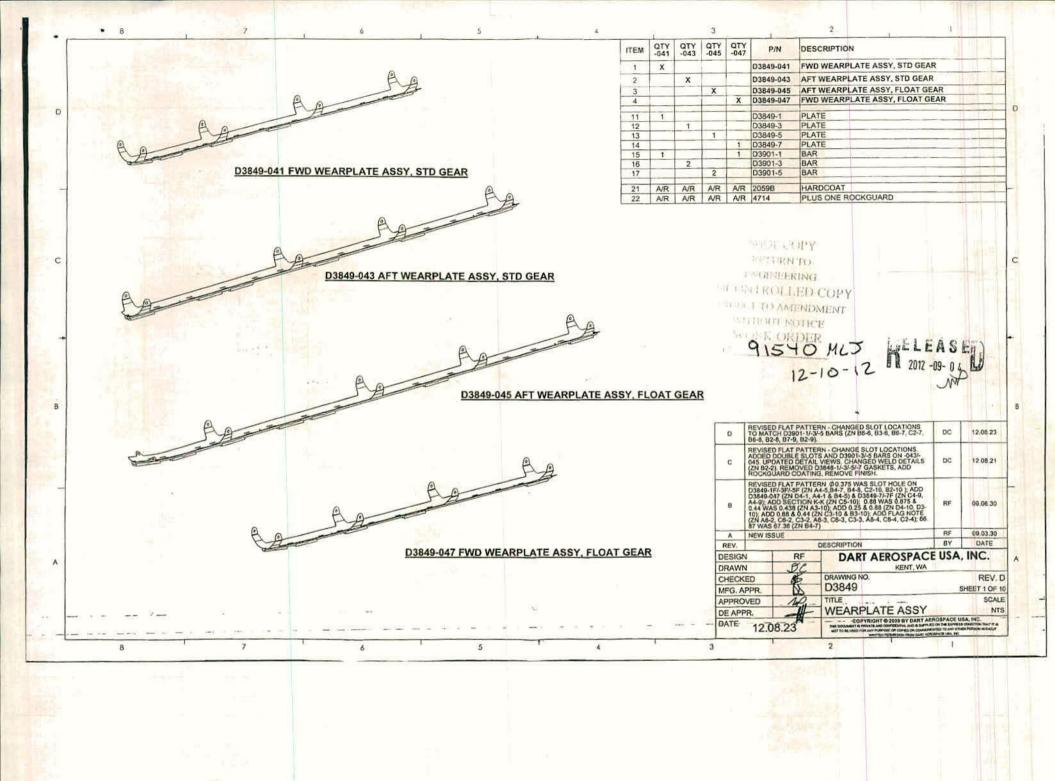
Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish



NCR: Ye														
	70									8	QA Closed:	[Date:	
Work Order	2)				DISPOSITION				_	DEF	PARTMENT			
Part No),				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining oforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jo d. Eng. Coo re/Packagin Supplie	r.	Engineering Quality Other
INCK INC					work order opdate		1	Large Fab	Composite			Suppli		
Root Cause	Date	Step	Qty		otion of work order update	1	Initial nief Eng	Act Descr	ion iption		Sign & Date	Verificat	ion	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							S							
						FAUI	LT CATE	GORY						
Landing	Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instructi Mainte Mislabe Misread Offset	on Incomplete ons Incomplete/L nance led	Inclear		Ovalized Over/Under Part Incorre Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Outside Dimensions

DQA:

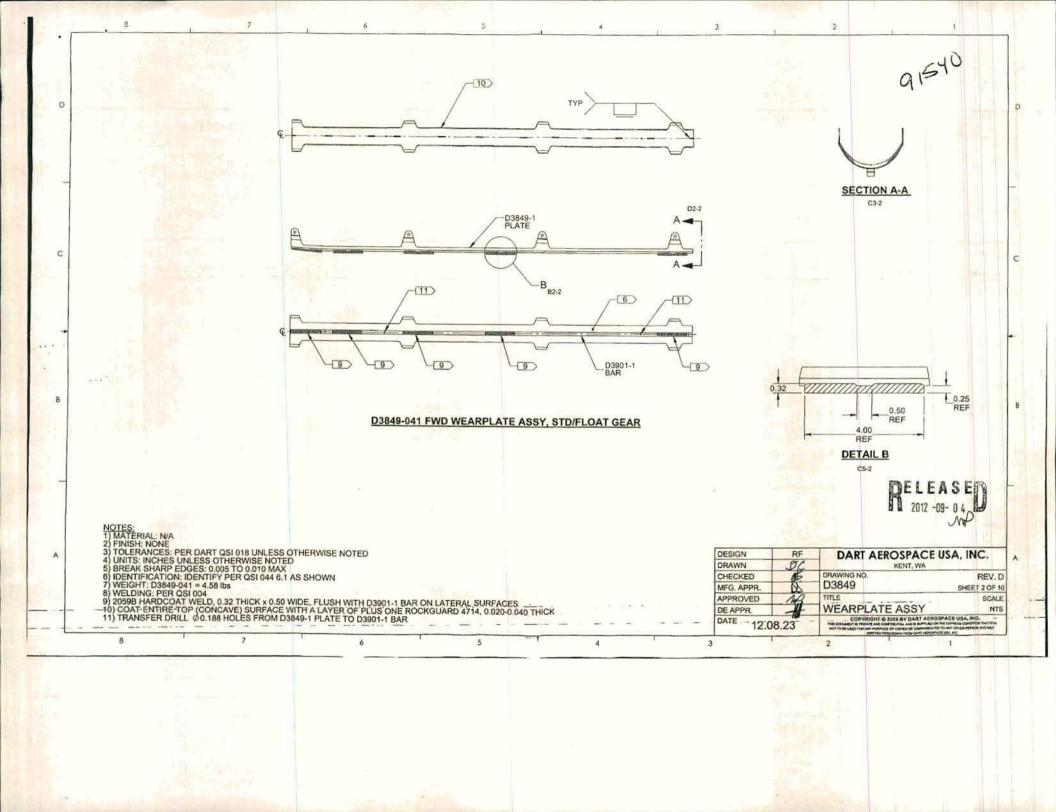
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Turning Sequence

Wave/Twist in Tube

Finish



											DQA:	Date	2:
NCR:	Yes	/ No				WORK ORDER NON-	100	VFORM	MANCE / UPD	ATE			
		10 SOM									QA Closed:	Date	2;
Wash Ond						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde	21.	_				Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	Vo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		-				Use-as-is		Therm	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR	Vo.					Work Order Update			Large Fab	Composite		Supplier	
Root					Descri	ption of work order update	П	Initial	Actio	n	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC Inspector
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Unapproved													
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Landi	ng (Gear				General			-		,	0	
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	0/5	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks					Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped					Burrs		Instruct	ions Incomplete/Un	nclear	Part Lost/M	issing	Wrong Stock Pulle
		Cuffs				Contamination		Mainte	enance		Part Moved		
		Heat Trea	it			Countersink		Mislabe	led		Positioned V	Vrong _	
		Inspection	n Strip in	Tube		Cut Too Short		Misread	i –		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

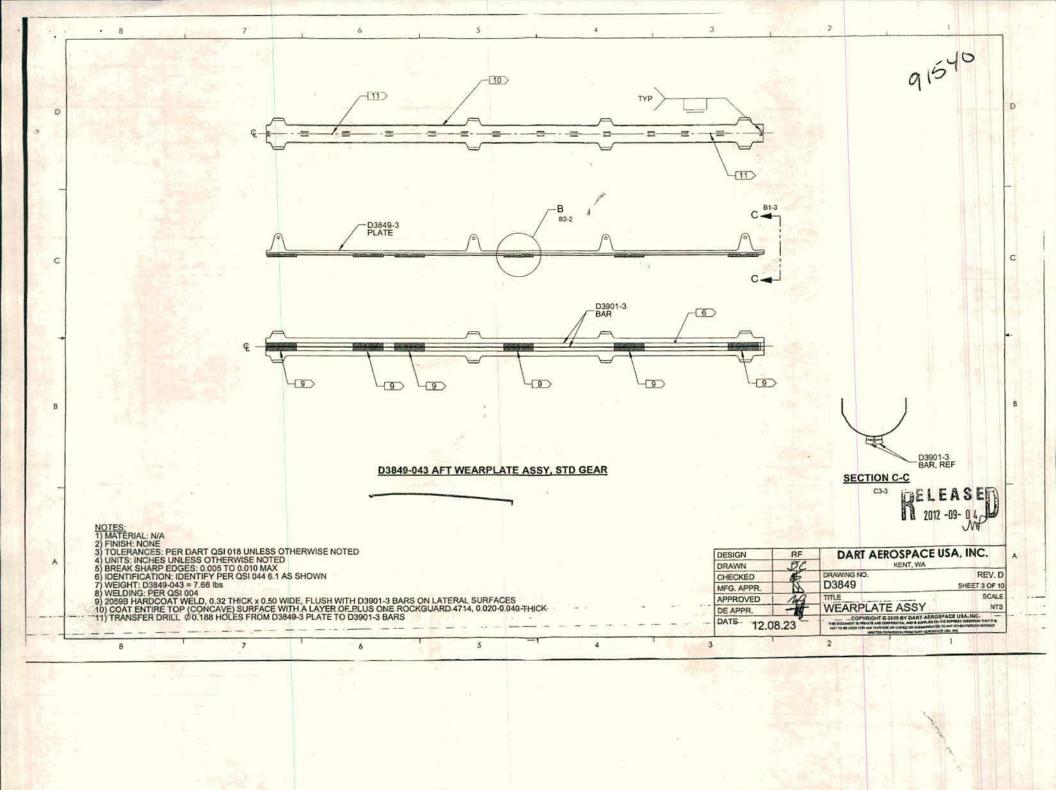
Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish



										DQ	A:	Date:	
NCR: Y	es / No				WORK ORDER NON-	cor	VFORN	ANCE / UPI	DATE				
						_				QA Close	d:	Date:	
Wash Orda	u.				DISPOSITION				AGAINST DE	PARTME	NT/PROC	ESS	
Work Orde					Rework	1		Skid-tube	Crosstube	7	Wa	ter Jet	Engineering
Part N	0				Scrap	1		Machining	Small Fab	P	rod. Eng.	500000000000000000000000000000000000000	Quality
1 014 14					Use-as-is	1		oforming	Finishing	→	tore/Pac		Other
NCR N	0				Work Order Update]		Large Fab	Composite]	Su	upplier	
Root				Descrip	otion of work order update	П	Initial	Act	ion	Sign &			
Cause	Date	Step	Qty	0	r Non-conformance	Ch	nief Eng	Descr	ription	Date	Veri	ification	QC Inspector
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Other		i .				1							
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Supplier						L							
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	Bending				Bend		Grain			Ovalized		_	Pressure/Forced
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	Cracks				Broken/Damaged		-	on Incomplete	_	Part Inco		-w	Weld
	Crushed/	Crimped			Burrs		-	ions Incomplete/I	Jnclear	Part Lost,			Wrong Stock Pulled
	Cuffs				Contamination		Mainte			Part Mov			
	Heat Trea				Countersink		Mislabe	led		Positione	The second second	_	_
	Inspectio	n Strip in	Tube		Cut Too Short		Misread			Power Lo	ss/Surge		Other
	Ripples in	Bend			Drill Holes	1	Offset						

Out of Sequence

Outside Dimensions

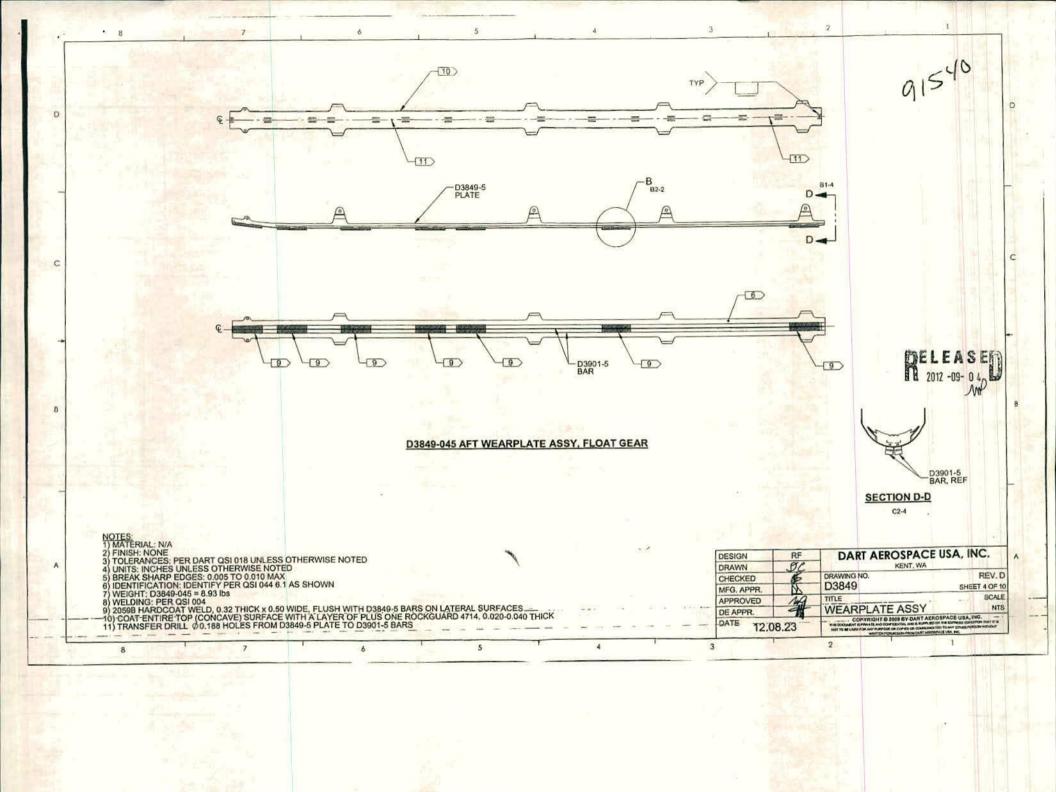
Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish



NCR: Y	es / No			WORK ORDER NOT	1-CO	NFORN	MANCE / UPDATE				
							8		QA Closed:	Da	te:
Work Orde Part N NCR N	10.			DISPOSITION Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crossi Machining Small Informing Finis Large Fab Compo	tube Fab hing	-	/PROCESS Water Jet d. Eng. Coor. re/Packaging Supplier	Quality Other
Root Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training	Date	Step	Qty	Description of work order update or Non-conformance		Initial hief Eng	Action Description		Sign & Date	Verificatio	n QC Inspector
Unapproved					5011	LT CATE	CORV				
1				General	FAU	LICATE	JURY				
Landi	Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in n Bend		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instructi Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/Unclear nance led		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Torque W	Javes in F	xtrusion	Drawing	1	IOut of C	alibration				

Outside Dimensions

Date:

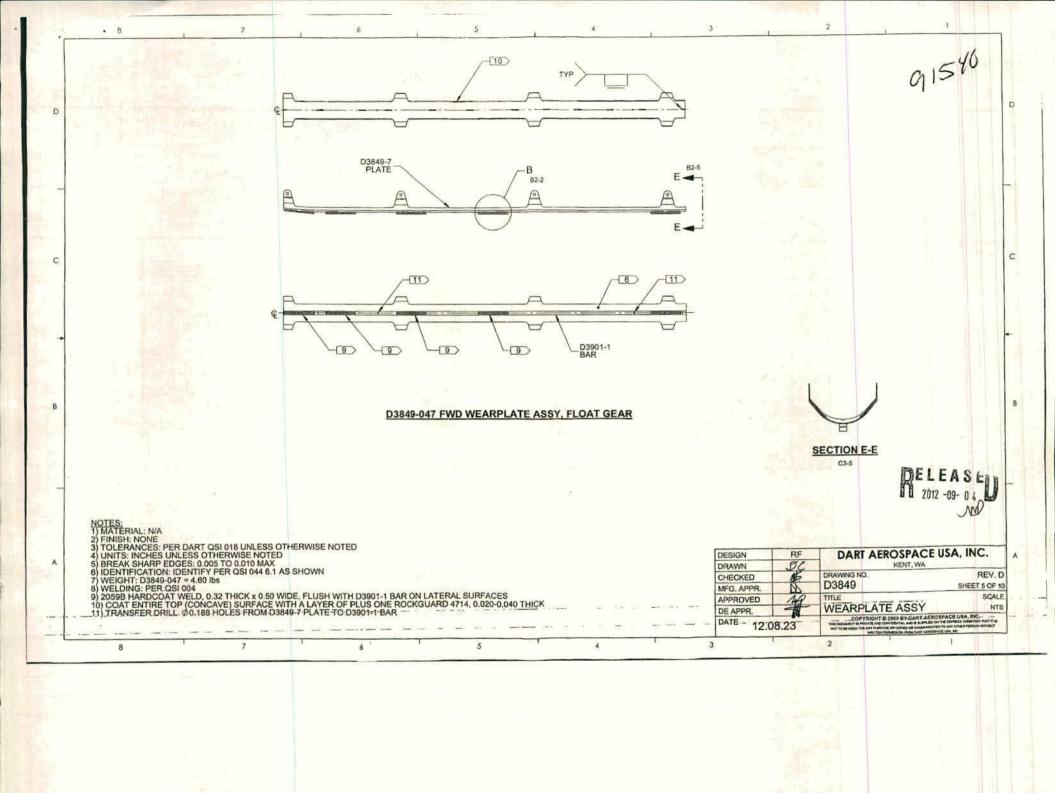
DQA:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



										DQA:	Date	2.	
NCR: Y	Yes / No				WORK ORDER NON-	ANCE / UPDAT	E			<u> </u>			
retariate in	(A) (100A)									QA Closed:	Date	2:	
					DISPOSITION			А	GAINST DE	PARTMENT	/PROCESS		
Work Orde	er:				Rework	٦		Skid-tube Cr	osstube		Water Jet	7	Engineering
Part N	lo				Scrap	1			mall Fab	Pro	d. Eng. Coor.	7	Quality
Factor					Use-as-is	1		WHO SERVICE OF THE SE	inishing		re/Packaging		Other
NCR N	No.				Work Order Update	1			mposite		Supplier		
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Root					ption of work order update		Initial	Action		Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descriptio	n	Date	Verification	+	QC Inspector
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Other											· ·	1	
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Supplier												1	67
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						AUI	T CATE	SORY				_	
Landir	ng Gear			_	General		1 3 3			ta sa z	Г		E 1920 IV
	Bending				Bend		Grain			Ovalized	-	_	Pressure/Forced
	Centre	Not Conce	ntric to O	/S	BOM/Route		Hardwa			Over/Under		$\overline{}$	Temperature/Cure
1	Cracks			_	Broken/Damaged		-	on Incomplete		Part Incorre	-	_	Weld
	Crushed	I/Crimped			Burrs			ions Incomplete/Uncle	ar	Part Lost/M	_		Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved			
	Heat Tr	eat			Countersink		Mislabe	led		Positioned \	Wrong		
	Inspecti	on Strip in	Tube		Cut Too Short		Misread			Power Loss,	/Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

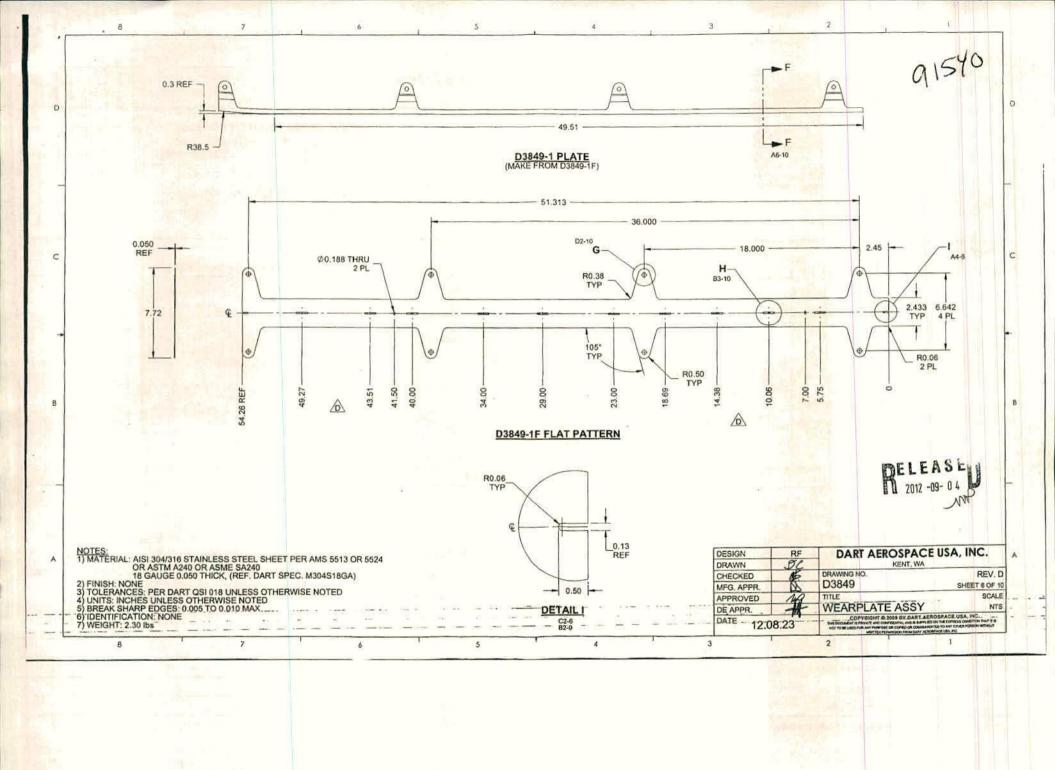
Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio



							DQA:	Date:	
NCR: Y	es / No			WORK ORDER NON-	CONFORM	ANCE / UPDATE	QA Closed:	Date:	
Work Orde	F1			DISPOSITION		AGAIN	NST DEPARTMENT		
Part N NCR N	0.			Rework Scrap Use-as-is Work Order Update	Ma Thermo	kid-tube Crosstu achining Small I forming Finish arge Fab Compos	Fab Pro	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data						Ti.			
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process					1				
Supplier					1				
Training									
Unapproved									
					FAULT CATEGO	ORY			
Landin	g Gear			General	ST		-	1700	
	Bending			Bend	Grain		Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to 0	D/S BOM/Route	Hardware		Over/Under	tolerance	Temperature/Cure
	Cracks			Broken/Damaged	Inspection	n Incomplete	Part Incorre	ct	Weld
	Crushed/	Crimped		Burrs	Instructio	ns Incomplete/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs			Contamination	Mainten	ance	Part Moved	1	
	Heat Trea	it		Countersink	Mislabele	d	Positioned V	Vrong	
	Inspectio	n Strip in	Tube	Cut Too Short	Misread		Power Loss/	Surge	Other
	Ripples in	Bend		Drill Holes	Offset				

Out of Sequence

Outside Dimensions

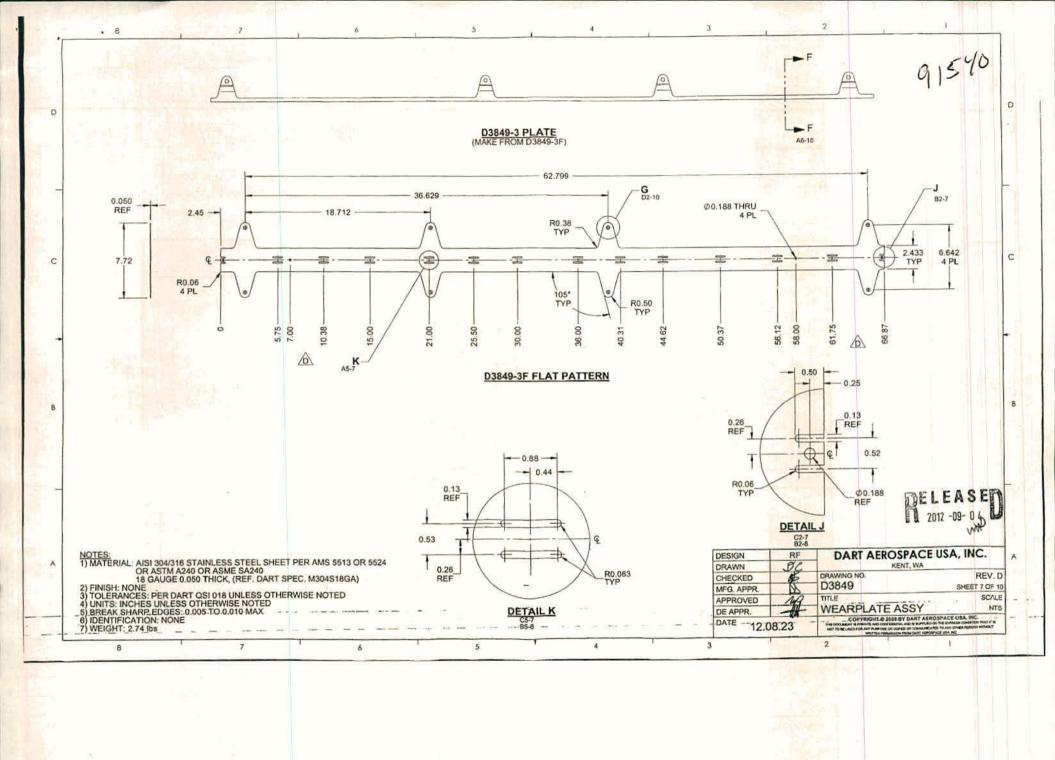
Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish



										DQA:	Dat	te:	
NCR: Y	es / No				WORK ORDER NON-	CONF	ORN	ANCE / UPDATE					
										QA Closed:	Dat	te:	
Work Orde	ar:				DISPOSITION			AGAINS	T DE	PARTMENT	PROCESS		
WOIK OIGE					Rework	1	U	Skid-tube Crosstub	e	1	Water Jet		Engineering
Part N	lo.				Scrap	1		Machining Small Fa		Pro	d. Eng. Coor.		Quality
					Use-as-is	Т	herm	oforming Finishir	g	Rec/Stor	e/Packaging		Other
NCR N	lo				Work Order Update			Large Fab Composit	e		Supplier		
Root				Descrip	otion of work order update	Init	ial	Action		Sign &			
Cause	Date	Step	Qty	0	or Non-conformance	Chief	Eng	Description		Date	Verification	n	QC Inspector
Doc/Data													
Equip/Tooling							- 1					1	
Operator							1						
Material													
Setup													
Other												-	
Process													
Supplier													
Training													
Unapproved													
						AULT C	CATEC	GORY					
Landin	ng Gear			_	General					1 - 2010 10			
	Bending				Bend		rain			Ovalized			Pressure/Forced
	Centre N	ot Concer	ntric to C)/S	BOM/Route	На	irdwai	e		Over/Under	tolerance	-	Temperature/Cure
	Cracks				Broken/Damaged			on Incomplete		Part Incorred		-	Weld
	Crushed/	Crimped			Burrs			ons Incomplete/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs				Contamination	M	ainte	nance		Part Moved			
	Heat Trea	at			Countersink	Mi	islabel	ed		Positioned V	Vrong	_	
	Inspectio	n Strip in	Tube		Cut Too Short	Mi	isread			Power Loss/	Surge		Other
	Ripples in	Bend			Drill Holes	Of	fset						

Out of Sequence

Outside Dimensions

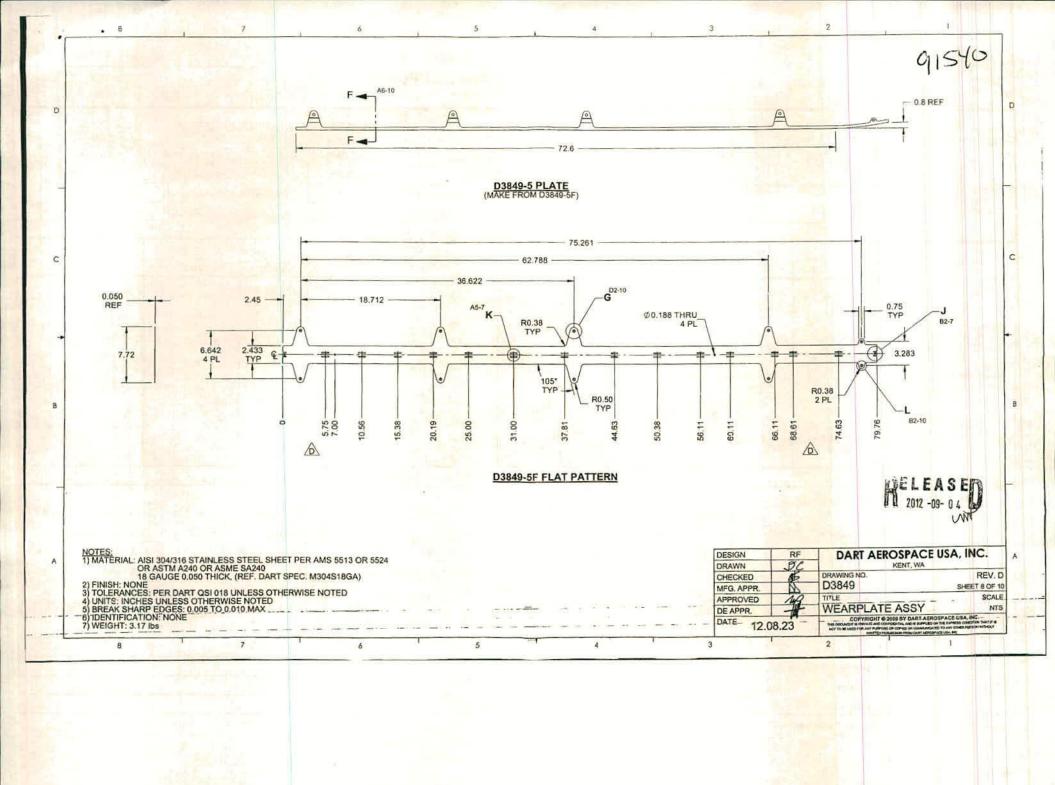
Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish



							DQA:	Date:	
NCR: Y	es / No			WORK ORDER NON-	CONFORM	ANCE / UPDATE	QA Closed:	Date:	
Work Orde	or:			DISPOSITION					
Part N	lo			Rework Scrap Use-as-is Work Order Update	Thermo	Skid-tube Crossi Machining Small oforming Finis Large Fab Compo	Fab Pro	Prod. Eng. Coor. Rec/Store/Packaging	
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved									
				F	AULT CATEG	ORY			
Landir	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in	Crimped at n Strip in		General Bend BoM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		on Incomplete ons Incomplete/Unclear nance	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss,	issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Sequence

Outside Dimensions

Turning Sequence

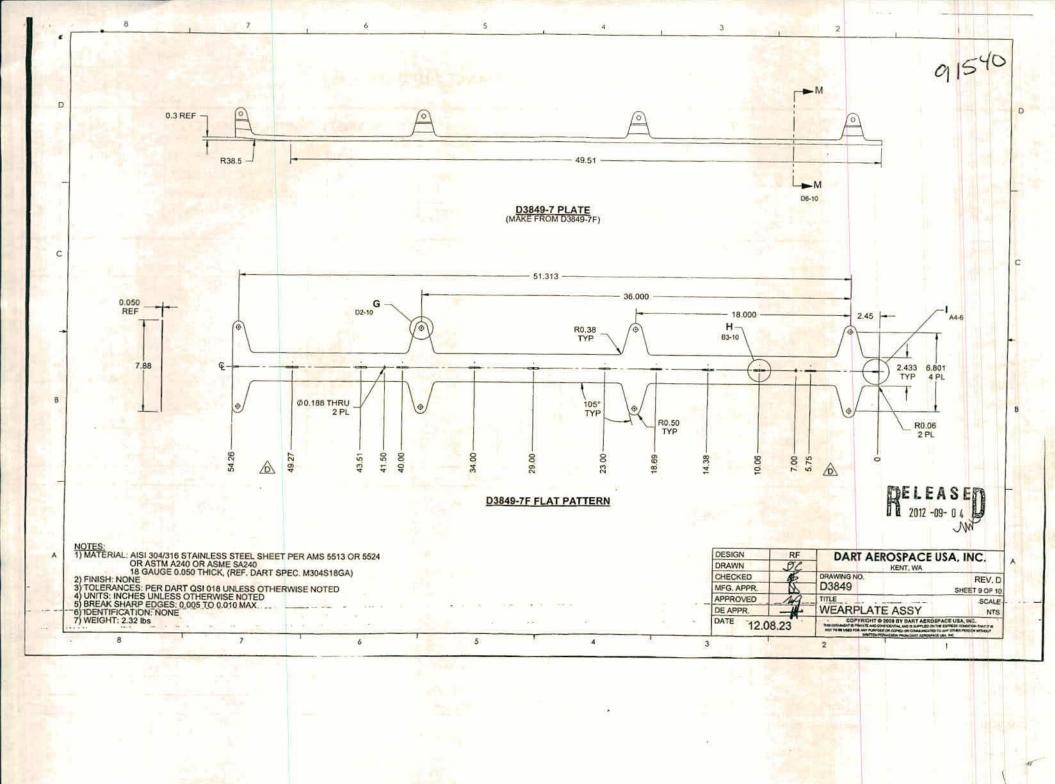
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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								DQA:	Date:		
NCR: Y	es / No			WORK ORDER NON-	CONFORM	IANCE / UP	PDATE				
								QA Closed:	Date:		
Work Orde	ır.			DISPOSITION	TION AGAINST DEPARTMENT/PROCESS						
WOIR Olde				Rework	Skid-tube Crosstub			Water Jet		Engineering	
Part N	lo.			100		Machining Small Fab					
	-			Use-as-is	Thermoforming Finishir			Rec/Sto	Other		
NCR N	lo			Work Order Update	Large Fab Composi		Composite		Supplier		
Root			П	Description of work order update	Initial	Ac	ction	Sign &			
Cause	Date	Step	Qty	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material	_										
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
					AULT CATE	ORY					
Landing Gear				General	П.			7]	
	Bending Centre Not Concentric to O/S			Bend		Grain		Ovalized		Pressure/Forced	
-		ot Concer	ntric to O			Hardware		Over/Under tolerance		Temperature/Cure	
-	Cracks	-		Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld Wrong Stock Pulled	
}	Crushed/	Crimped		Burrs	-	Instructions Incomplete/Unclear					
ł	Cuffs			Contamination		Maintenance		Part Moved Positioned Wrong			
-	Heat Trea		Tibe	Countersink	200000000000000000000000000000000000000	Mislabeled				Other	
	Inspection Strip in Tube			Cut Too Short Drill Holes	Offset	Misread		Power Loss,	ourge	Dellet	
1	Ripples in Bend Torque Waves in Extrusion					alibration		-			
	Torque V	vaves in E	xtrusion	Drawing	Out of C	Out of Calibration					

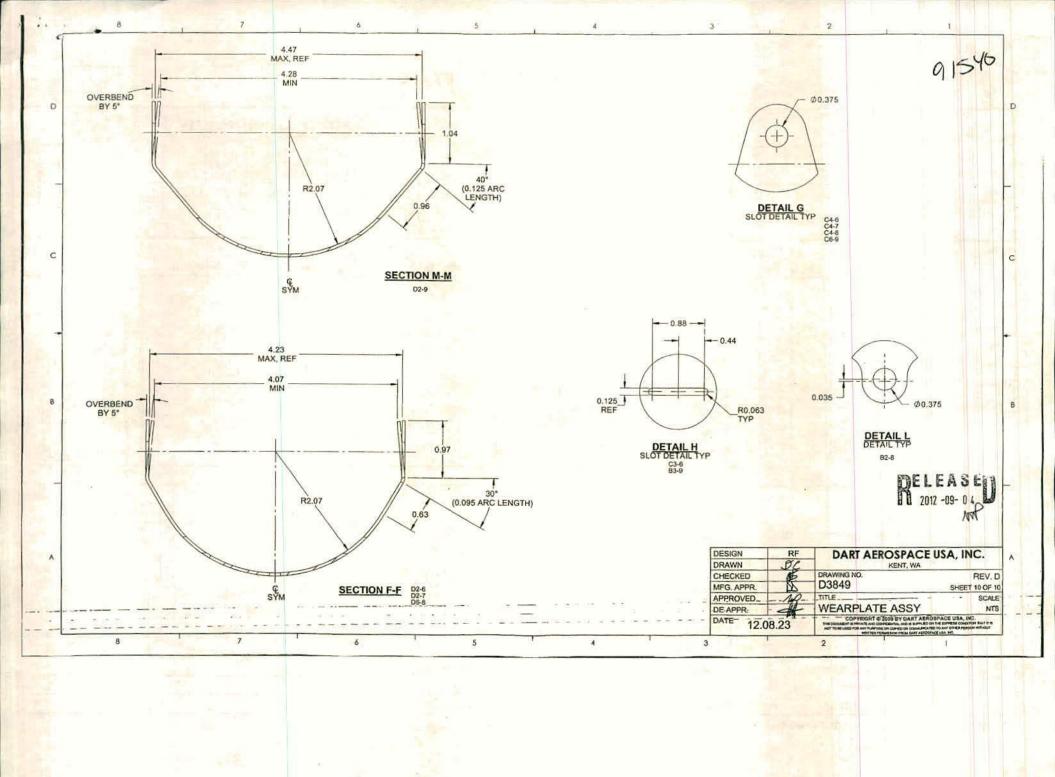
Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Finish



					DQA	A: Date:			
		WORK ORDER NON-	CONFORM	ANCE / UPDATE		d: Date:			
	4	DISPOSITION	AGAINST DEPARTMENT/PROCESS						
		Rework Scrap Use-as-is Work Order Update	Ma Thermo	achining Sm oforming Fir	all Fab Pr nishing Rec/St	100	Engineering Quality Other		
Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
24									
		F	AULT CATEGO	DRY	- 11	1 2 2			
Vot Conce /Crimped Pat on Strip in		Broken/Damaged Burrs Contamination Countersink Cut Too Short	Inspection Instruction Maintena Mislabele Misread	n Incomp <mark>le</mark> te ns Incomplete/Unclear ance d	Part Incom Part Lost/I Part Move Positioned	rect Missing ed I Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
	Step Not Conce	Step Qty Not Concentric to C /Crimped eat on Strip in Tube	DISPOSITION Rework Scrap Use-as-is Work Order Update Step Qty Description of work order update or Non-conformance Step Qty Or Non-conformance General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink on Strip in Tube Cut Too Short	DISPOSITION Rework Scrap Use-as-is Work Order Update Step Qty Description of work order update or Non-conformance General Bend BOM/Route Broken/Damaged Instruction Instruction Maintena Contamination Countersink Cout Too Short Misread	DISPOSITION Rework Scrap Use-as-is Work Order Update	WORK ORDER NON-CONFORMANCE / UPDATE DISPOSITION	WORK ORDER NON-CONFORMANCE / UPDATE DISPOSITION Rework Scrap Use-as-is Work Order Update Or Non-conformance Step Qty Description of work order update or Non-conformance General Bend Step Otto O/S Broken/Damaged Instructions Incomplete Instruc		

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio